

Date: Monday, 15/12/2008 11:04:14 AM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 44083
Estimate Number : 10606
P.O. Number :
This Issue : 15/12/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL /MED FAB
Previous Run : 43724
Written By :
Checked & Approved By : MF 08-12-15
Comment : Est: A 05.05.12 New issue KJ/JLM
Est Rev:B Now on Waterjet 06-10-03 JLM

Drawing Name : WEARPLATE
Part Number : D33193
Drawing Number : D3319 REV. B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 22/12/2008 Qty: 12 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S18GA 1010/1025 SHEET .048



Comment: Qty.: 3.4150 sf(s)/Unit Total : 40.9802 sf(s)
1010/1025/A21/6aA SHEET .048" Thick
Batch: 109948 1B 9-1-7

2.0 WATER JET 109022 x9 = 31^{SF} FLOW WATER JET
x3 = 10^{SF}



Comment: FLOW WATER JET
1-Cut as per Dwg D3319
Dwg Rev: B
Prog Rev: B

1B 9-1-7



2-Deburr if necessary 1B 9-1-7

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B 9-1-7

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

509/01/08 (12)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

Date: Monday, 15/12/2008 11:04:14 AM
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Drawing Name: WEARPLATE

Job Number: 44083

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SB 09/01/12

(12)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 09/01/12

(X12)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

Batch M109479

EL 9-1-14

(X12)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/01/14

(X12)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/14

(X12)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:10

OVEN TEMPERATURE:

320°

FINISH TIME:

10:40

FL 09/01/14

(12)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MS

09-01-14

(X12)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

Date: Monday, 15/12/2008 11:04:15 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 44083

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: ST496

JS 09/01/15 (X12)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/15 JS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09.06.15

DART AEROSPACE LTD		Work Order:	44083
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	X			
74.420	+/-0.010	74.420	X			
62.770	+/-0.010	62.770	X			
52.890	+/-0.010	52.890	X			
30.790	+/-0.010	30.790	X			
8.690	+/-0.010	8.691	X			
0.60	+/-0.030	.601	X			
2.690	+/-0.010	2.697	X			
2.940	+/-0.010	2.948	X			
3.527	+/-0.010	3.519	X			
4.518	+/-0.010	4.511	X			
Ø0.190	+0.005/-0.001	.193	X			
2.940	+/-0.010	2.948	X			
2.940	+/-0.010	2.948	X			
2.690	+/-0.010	2.697	X			
5.063	+/-0.010	5.061	X			
6.163	+/-0.010	6.161	X			
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	.317 x .608	X			
0.048	+/-0.010	.047	X			

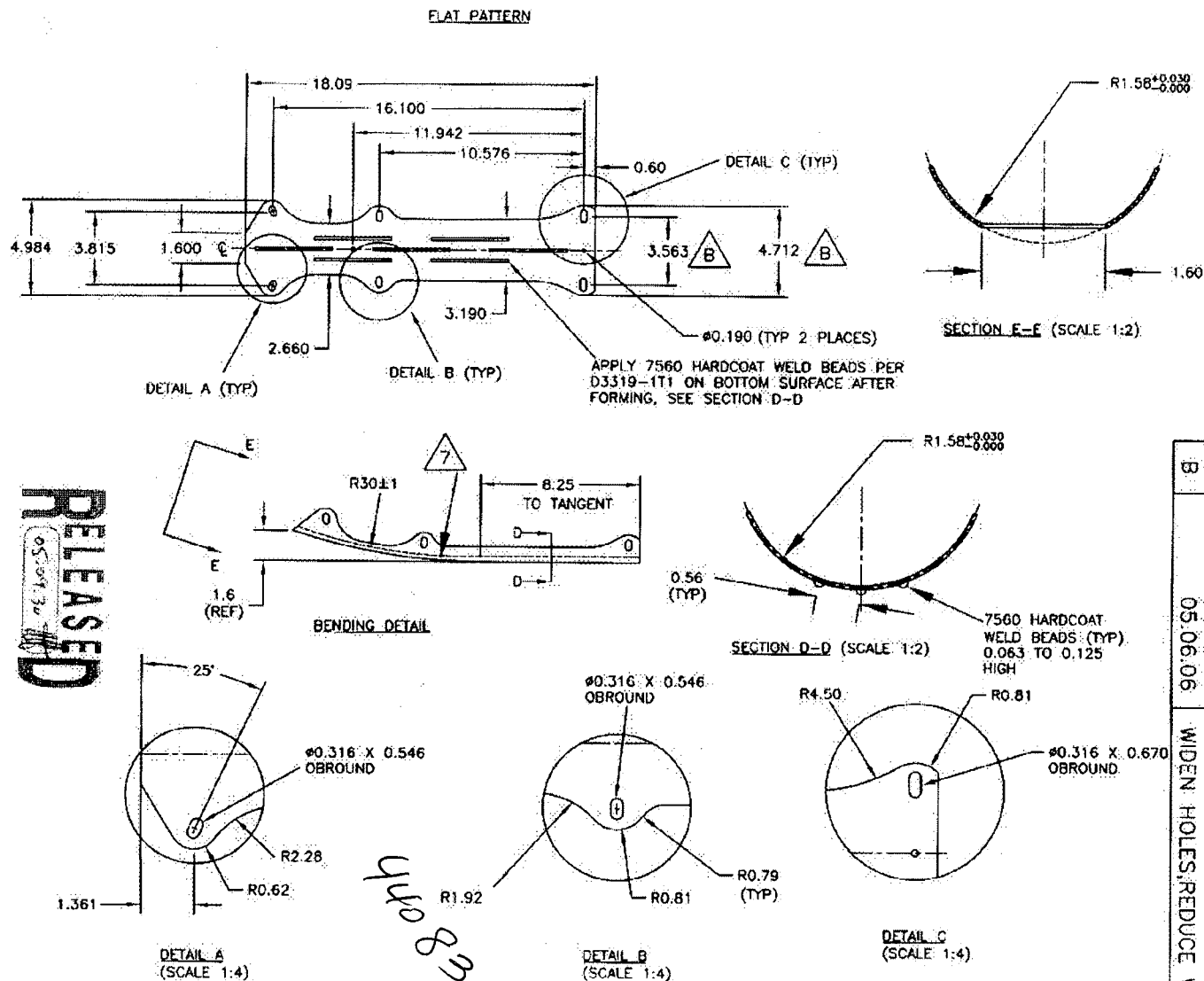
Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-1-7	Date: 09/01/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	IB



ALNO 0303000136

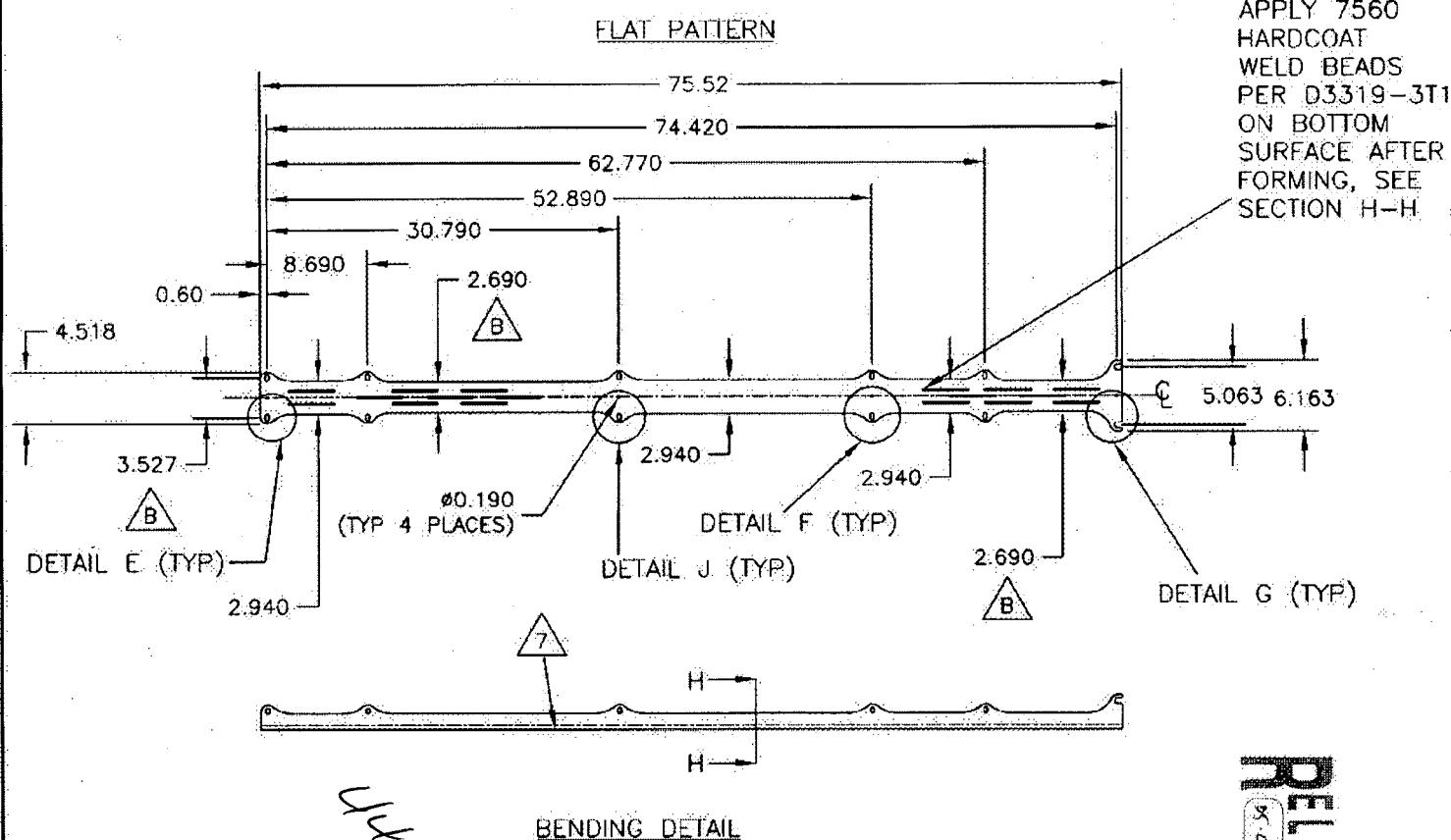
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A1	04	HAMMERSBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.06.06	05.06.06	D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:8
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05-01-30



REFERENCE ONLY

DART

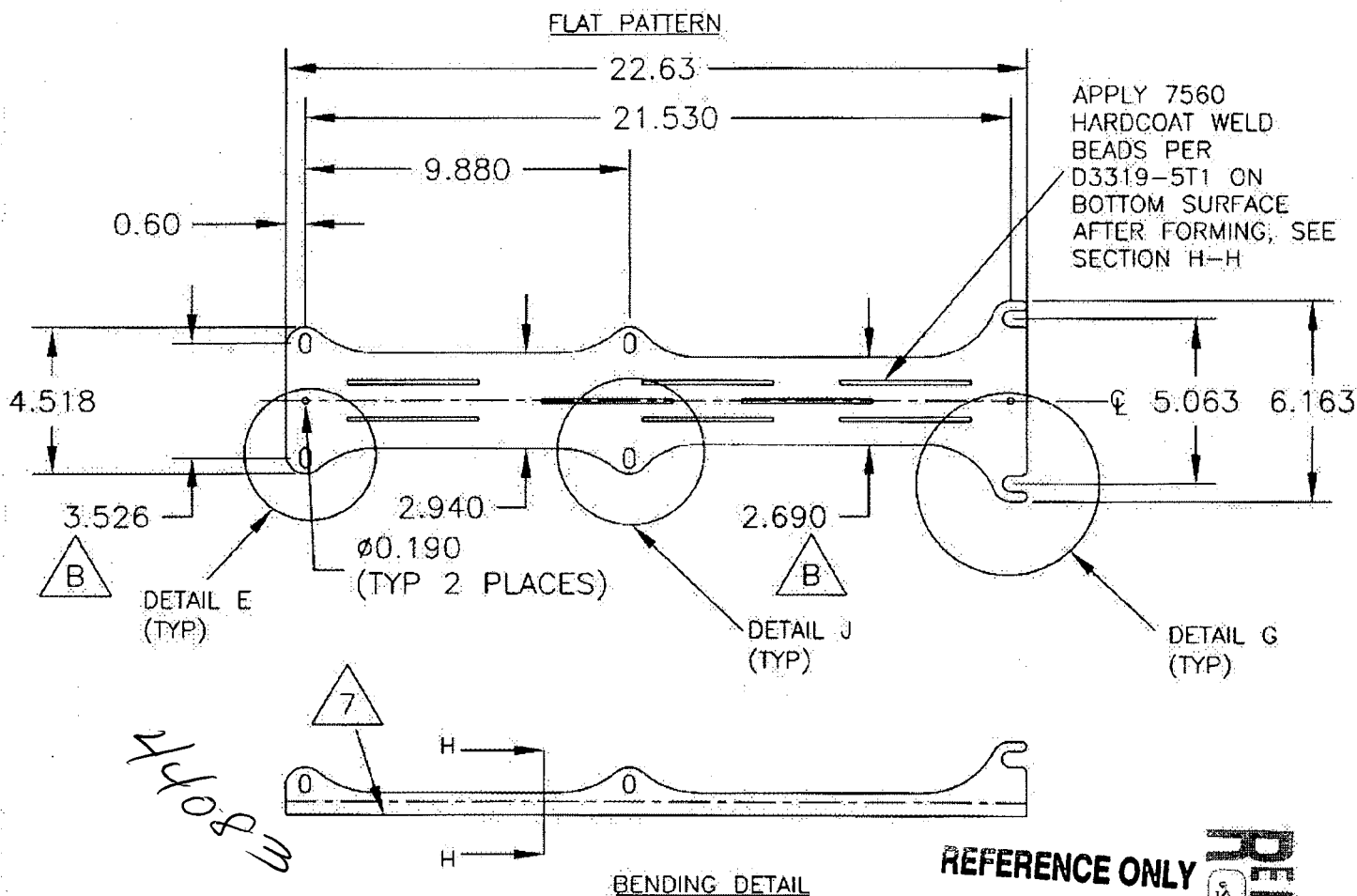
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05.06.06					
TITLE	DRAWING NO.	SHEET 2 OF 5	SCALE	REV. B	
WEARPLATE	D3319		1:15		

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED

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D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4:3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05-07-30-10

DART

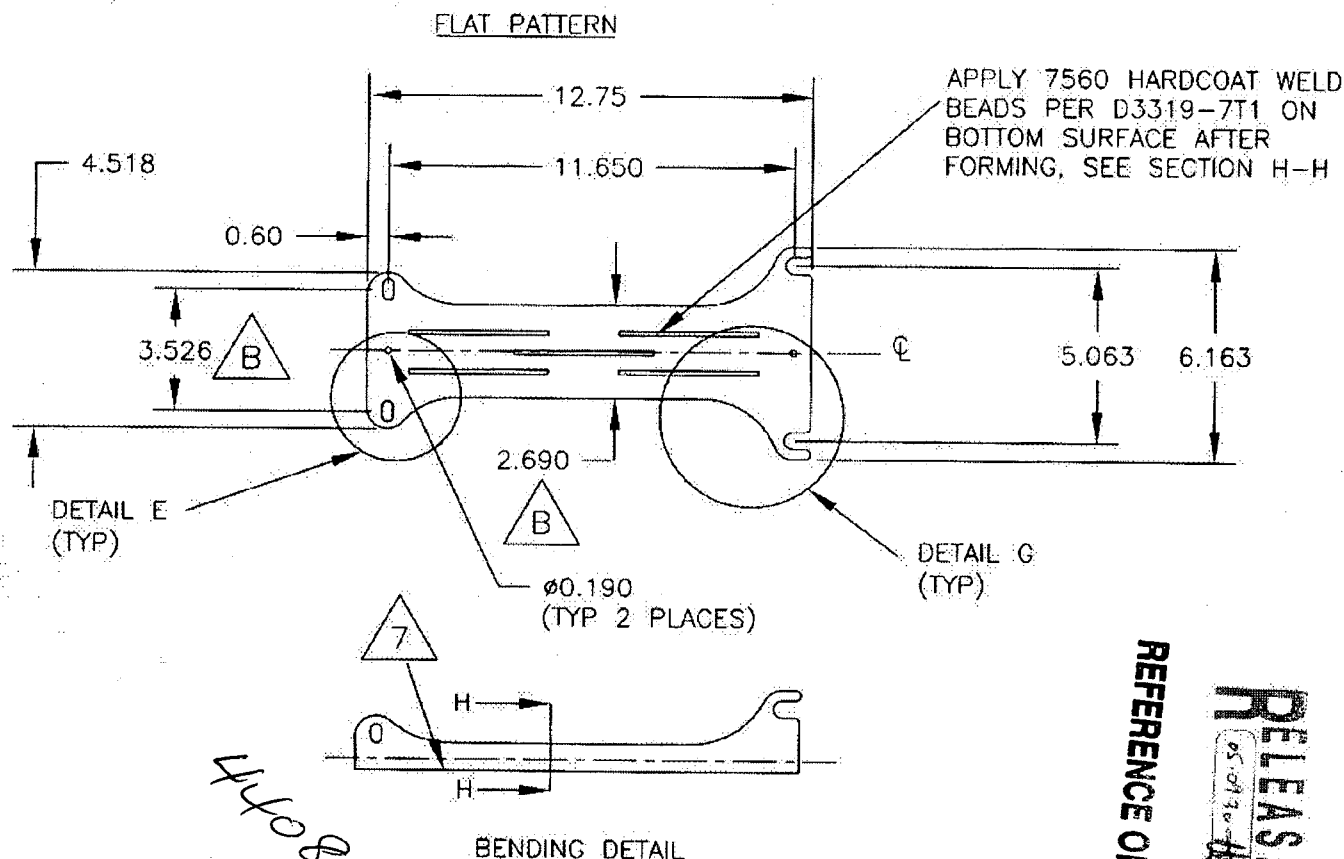
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CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 3 OF 5
	TITLE	SCALE
	WEARPLATE	1:5



DESIGN	PH	DRAWN BY	GH	DART AEROSPACE LTD
CHECKED	GH	APPROVED	GH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
		WEARPLATE		SHEET 4 OF 5
				SCALE 1:5

RELEASED
05.01.30-41

REFERENCE ONLY

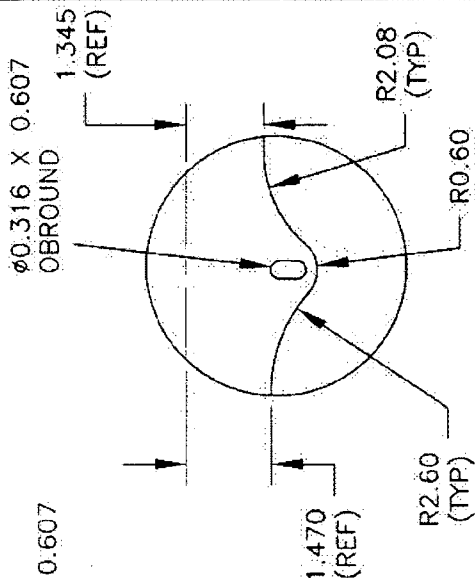


D3319-7 WEARPLATE

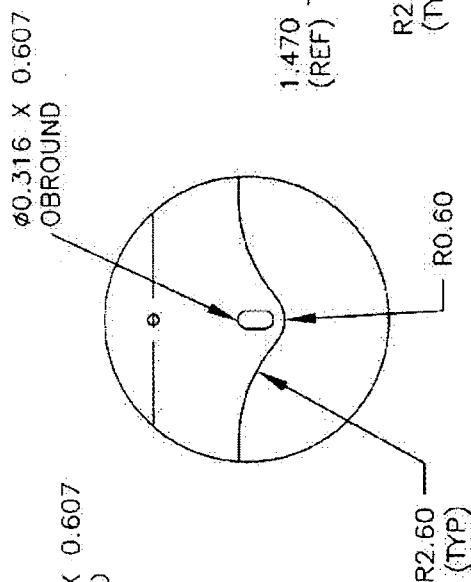
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- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



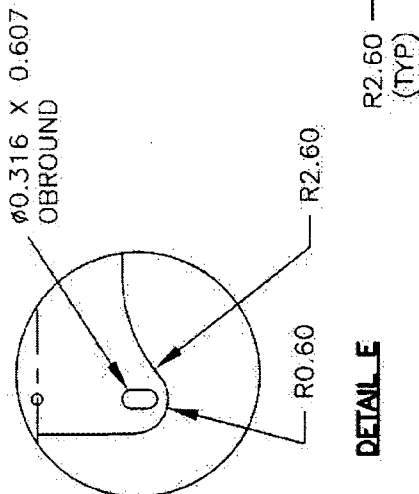
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3



DETAIL J



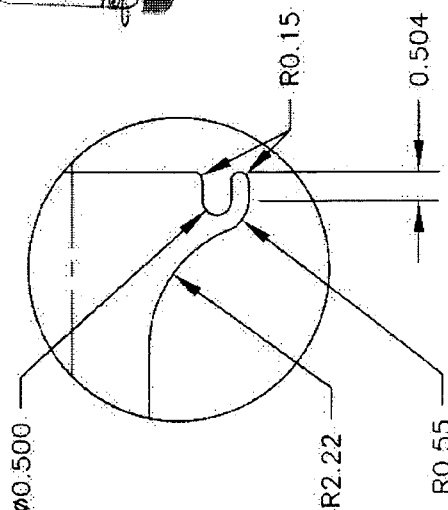
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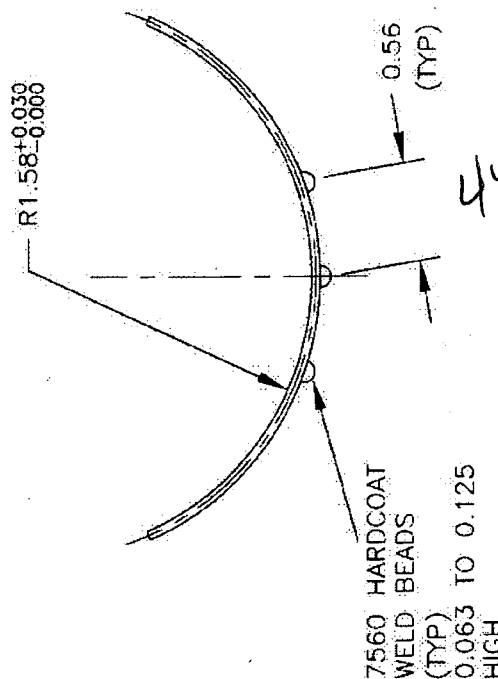
DETAIL E

RELEASED
05.09.30

REFERENCE ONLY



DETAIL G



**SECTION H-H
(SCALE 1:1)**

44083

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